

Date: Wednesday, 18/06/2008 1:33:02 PM  
 User: Julie Lecocq

## Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	AFT BASE
<b>Job Number</b> :	39937		
<b>Estimate Number</b> :	13033		
<b>P.O. Number</b> :		<b>Part Number</b> :	D36519
<b>This Issue</b> :	18/06/2008	<b>Drawing Number</b> :	D3651 REV.B
<b>Prsht Rev.</b> :	NC	<b>Project Number</b> :	N/A
<b>First Issue</b> :	/ /	<b>Drawing Revision</b> :	B
<b>Previous Run</b> :	37138	<b>Material</b> :	
<b>Written By</b> :		<b>Due Date</b> :	07/07/2008
<b>Checked &amp; Approved By</b> :	JUL 08-6-18	<b>Qty:</b>	2
<b>Comment</b> :	Est Rev:A New Issue 07-09-27 DD verified by: EC Est Rev:B ECN 1113P 08-01-22 DD Est Rev:C ecn1162 08-04-02 DD verified by: EC		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M304S26GA	304/316 0.018 SHEET
-----	-----------	---------------------



1.5



**Comment:** Qty.: 0.4526 sf(s)/Unit Total: 0.9051 sf(s)  
 304/316 SS sheet 26 ga (0.018" thick)  
 Batch: 108415 HB 8-6-26

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



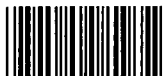
**Comment:** FLOW WATER JET  
 1-Cut as per Dwg D3651  
 Dwg Rev: B  
 Prog Rev: B

HB 8-6-26

(3)

2-Deburr if necessary HB 8-6-26

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



HB 8-6-26

**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
-----	-----	--------------



08-06-27 (3)

**Comment:** SECOND CHECK

5.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------

**Comment:** PACKAGING RESOURCE #1

Identify and stock  
 Location: GA

SL 08/07/21

(3)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 18/06/2008 1:33:02 PM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT BASE

Job Number: 39937

Part Number: D36519

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



08/07/21 *[Signature]*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



*U 08.07.21*

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 89931
<b>Description:</b> Inside Doubler		<b>Part Number:</b> D3651-9
<b>Inspection Dwg:</b> D3651	<b>Rev:</b> B	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

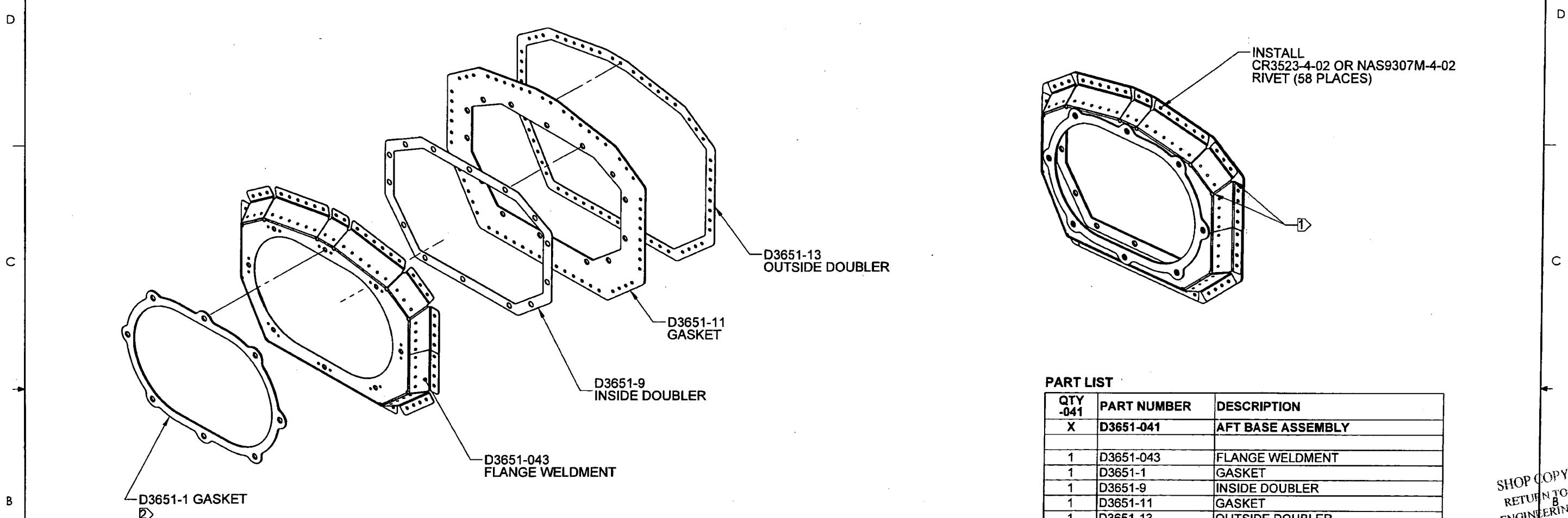
☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.25	+0.004/-0.001	.253	*		✓	
0.250	+/-0.010	.250	*		✓	
0.500	+/-0.010	.502	*		✓	
6.33	+/-0.030	6.333	*		✓	
9.81	+/-0.030	9.81	*		✓	
2.818	+/-0.010	2.818	*		✓	
2.100	+/-0.010	2.100	*		✓	
2.100	+/-0.010	2.100	*		✓	
2.575	+/-0.010	2.575	*		✓	
2.000	+/-0.010	2.000	*		✓	
5.514	+/-0.010	5.514	*		✓	
2.750	+/-0.010	2.750	*		✓	
2.200	+/-0.010	2.200	*		✓	
2.371	+/-0.010	2.371	*		✓	
1.325	+/-0.010	1.327	*		✓	
3.112	+/-0.010	3.112	*		✓	
1.400	+/-0.010	1.400	*		✓	
5.514	+/-0.010	5.515	*		✓	

<b>Measured by:</b> [Signature]	<b>Audited by:</b> [Signature]	<b>Prototype Approval:</b> N/A
<b>Date:</b> 8-6-26	<b>Date:</b> 08-06-27	<b>Date:</b> N/A

Rev	Date	Change	Revised by	Approved
A	08.04.17	New Issue	KJ/DD [Signature]	[Signature]

8 7 6 5 4 3 2 1



PART LIST		
QTY -041	PART NUMBER	DESCRIPTION
X	D3651-041	AFT BASE ASSEMBLY
1	D3651-043	FLANGE WELDMENT
1	D3651-1	GASKET
1	D3651-9	INSIDE DOUBLER
1	D3651-11	GASKET
1	D3651-13	OUTSIDE DOUBLER
58	CR3523-4-02 or NAS9307M-4-02	RIVET

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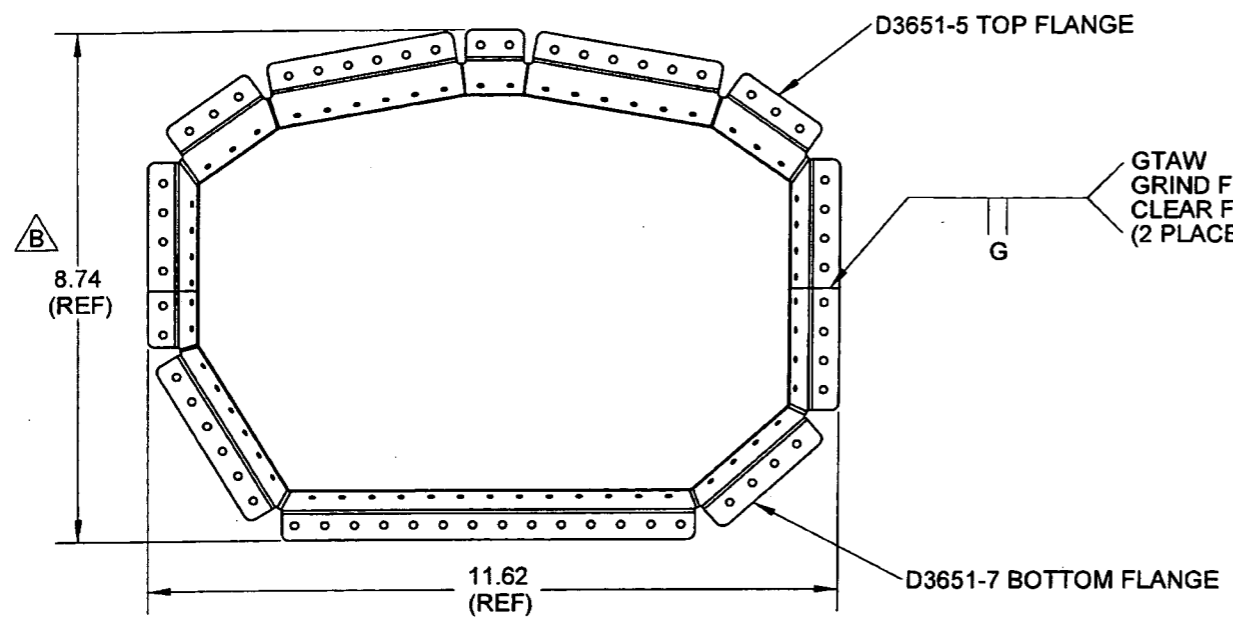
**D3651-041 AFT BASE ASSEMBLY**

- D3651-041 NOTES:**
- 1) SEAL ALL MATING SURFACES AND GAPS USING PROSEAL 700 FIRE WALL SEALANT
  - 2) INSTALL D3651-1 USING 3M HIGH PERFORMANCE CONTACT ADHESIVE 1357
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: NONE
  - 7) WEIGHT: 1.6 lbs

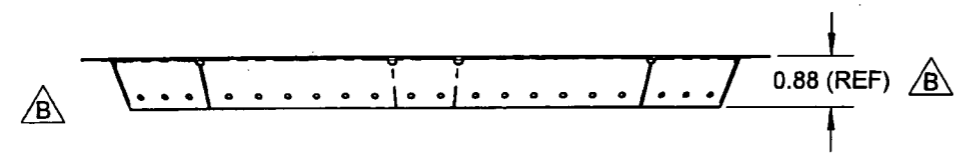
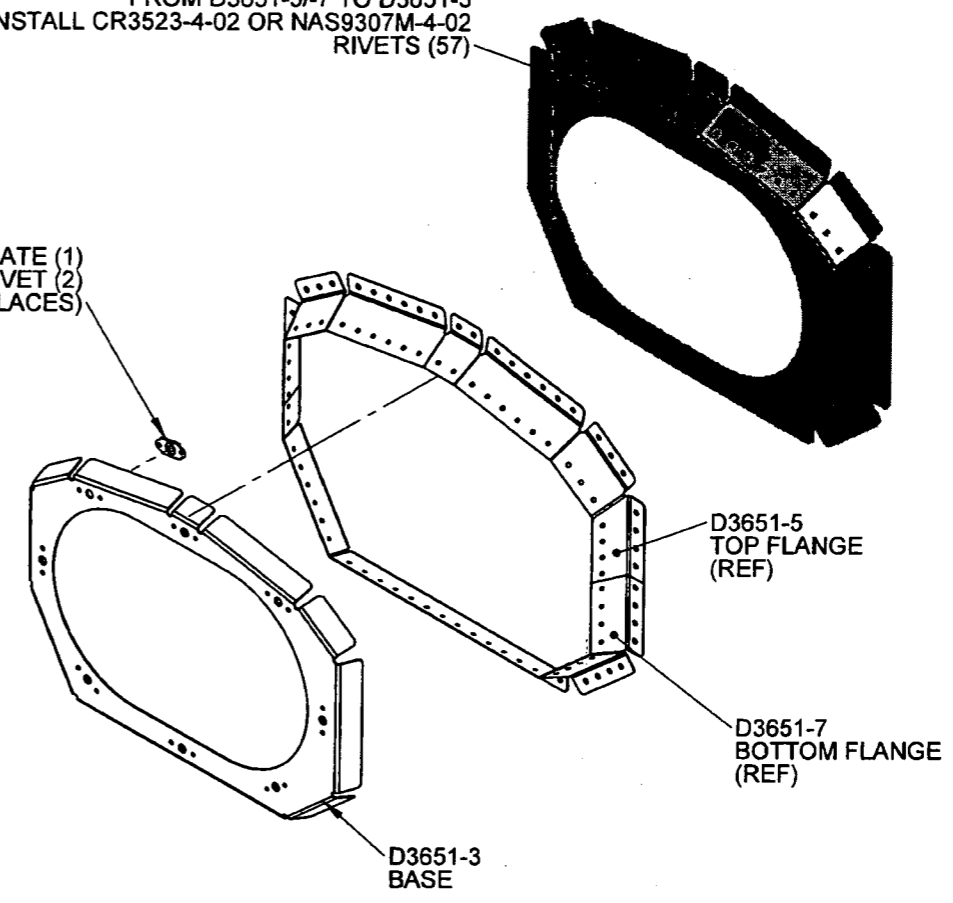
B	SHEET 1: GENERAL UPDATE SHEET 2: 8.74 WAS 8.50; 0.88 WAS 0.98; REMOVED ANGLE SHEETS 4, 5, 6, 8 & 9: GENERAL DIMENSIONAL UPDATE SHEET 7: 5.514 WAS 5.504	RF	08.01.07
A	NEW ISSUE	RF	07.11.07
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	CE	DRAWING NO.	REV. B
MFG. APPR.	MD	D3651	SHEET 1 OF 9
APPROVED	MD	TITLE	SCALE
DE APPR.		AFT BASE ASSEMBLY	1:4
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8 7 6 5 4 3 2 1

TRANSFER DRILL Ø0.129 (#30 DRILL)  
FROM D3651-5/-7 TO D3651-3  
INSTALL CR3523-4-02 OR NAS9307M-4-02  
RIVETS (57)



MS21060-3K NUTPLATE (1)  
MS20427M3-3 RIVET (2)  
(8 PLACES)



**D3651-043 FLANGE WELDMENT**

QTY -043	PART NUMBER	DESCRIPTION
X	D3651-043	FLANGE WELDMENT
1	D3651-3	BASE
1	D3651-5	TOP FLANGE
1	D3651-7	BOTTOM FLANGE
16	MS20427M3-3	RIVET
8	MS21060-3K	NUTPLATE
57	CR3523-4-02 or NA9307M-4-02	RIVET

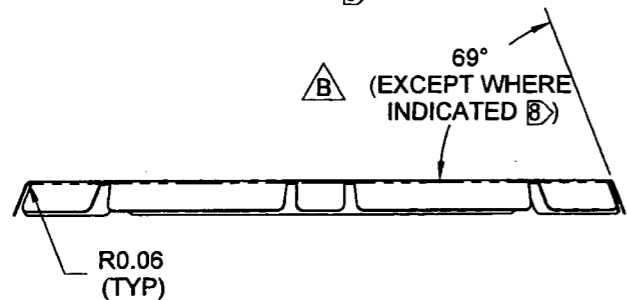
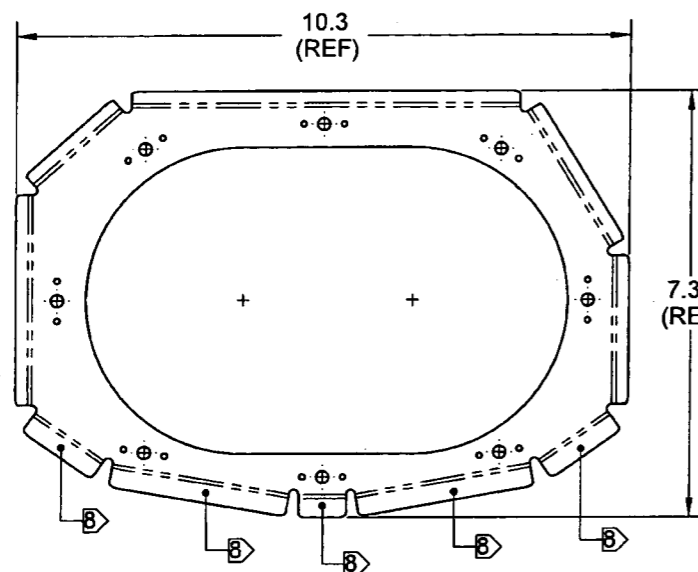
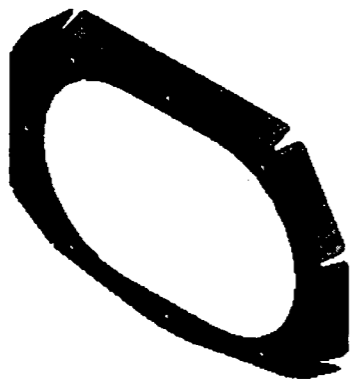
- D3651-043 NOTES:**
- 1) WELD PER QSI 004
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: NONE
  - 7) WEIGHT: 0.76 lbs

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APPROVED	ME	SHEET 2 OF 9
DE APPR.	ME	TITLE AFT BASE ASSEMBLY
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8 7 6 5 4 3 2 1

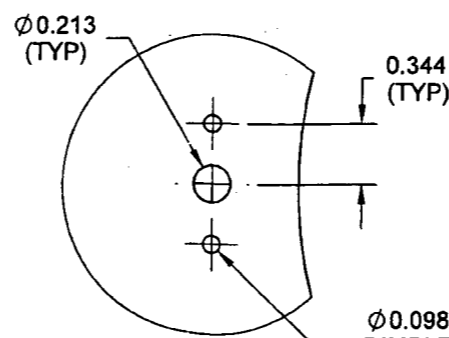
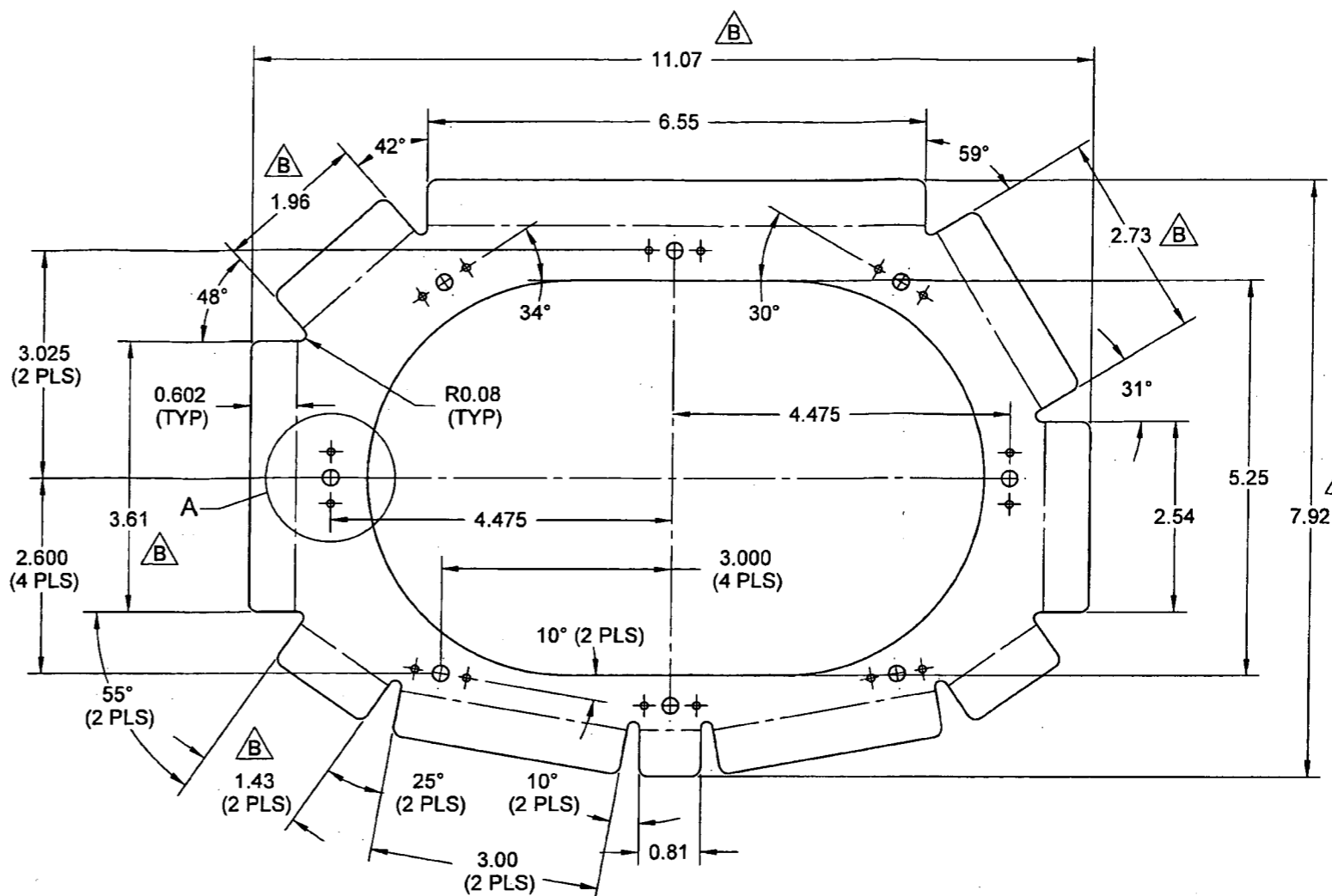
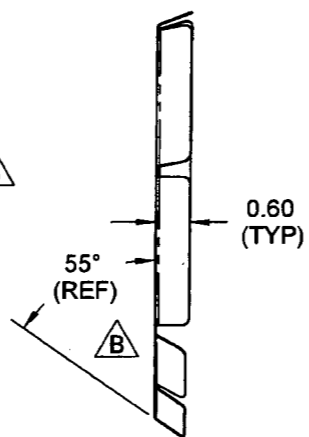




**D3651-3 BASE**  
(MAKE FROM D3651-3F FLAT PATTERN)

**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 (26 GAUGE) SHEET, PER MIL-S-5019 (REF. DART SPEC. M304S26GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.27 lbs
- 8) BEND TO 55° WHERE INDICATED



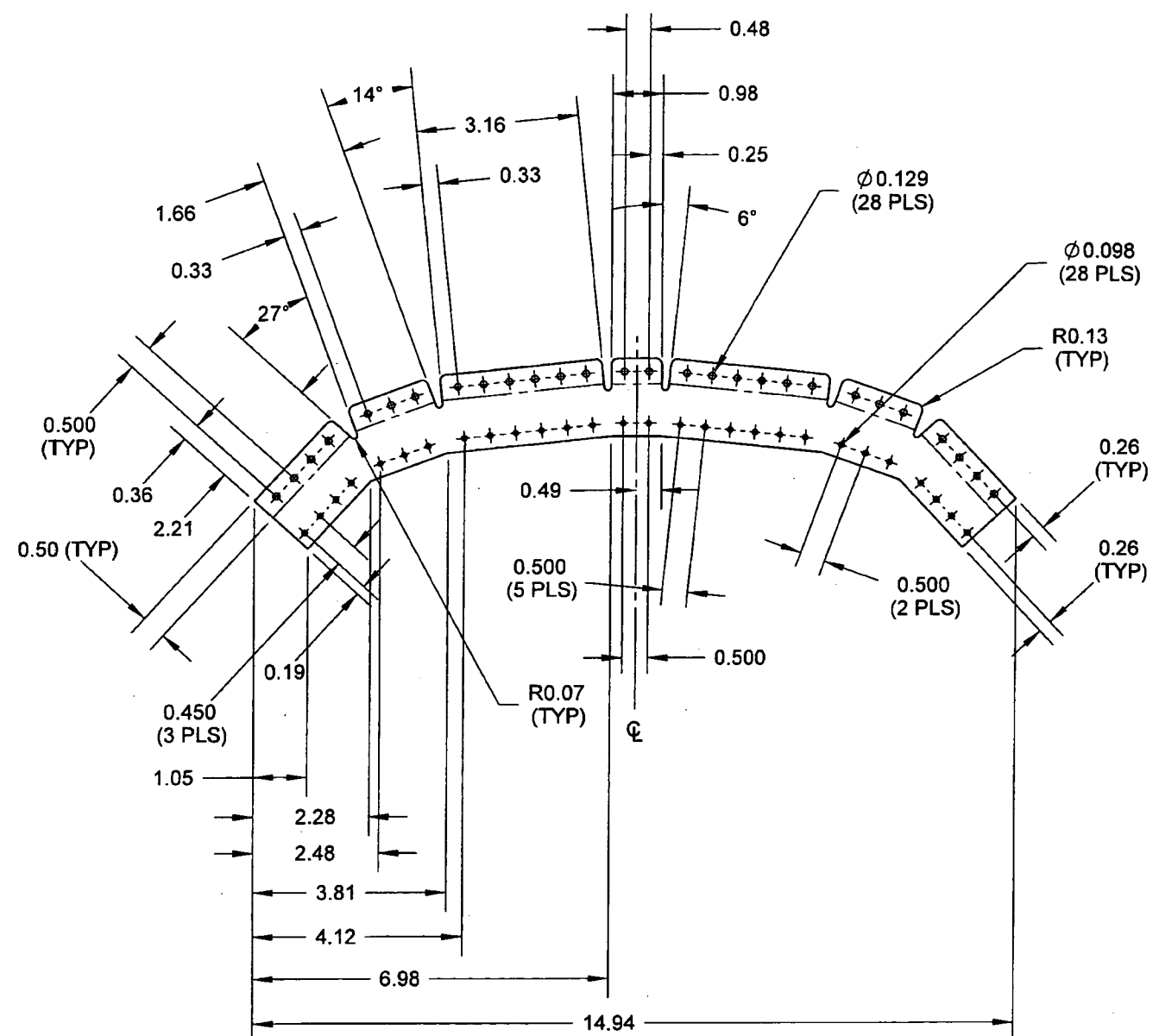
Ø0.098 (TYP)  
DIMPLE HOLES  
FOR MS20427M3  
RIVET

**DETAIL A**

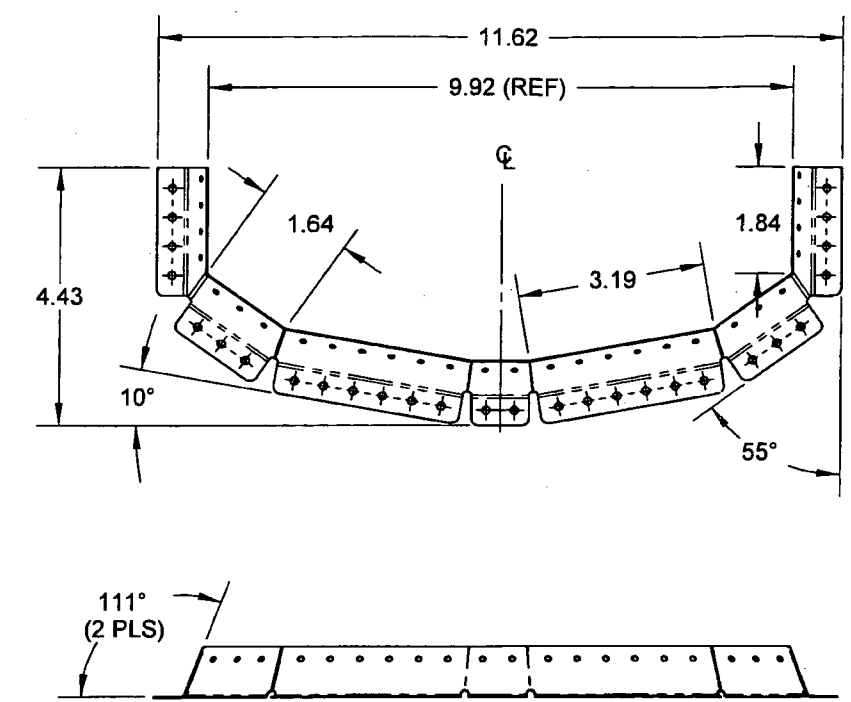
**D3651-3F FLAT PATTERN**

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MFG. APPR.	ME	D3651	SHEET 4 OF 9
APPROVED	ME	TITLE	SCALE
DE APPR.	ME	AFT BASE ASSEMBLY	1:2
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**D3651-5F FLAT PATTERN** B



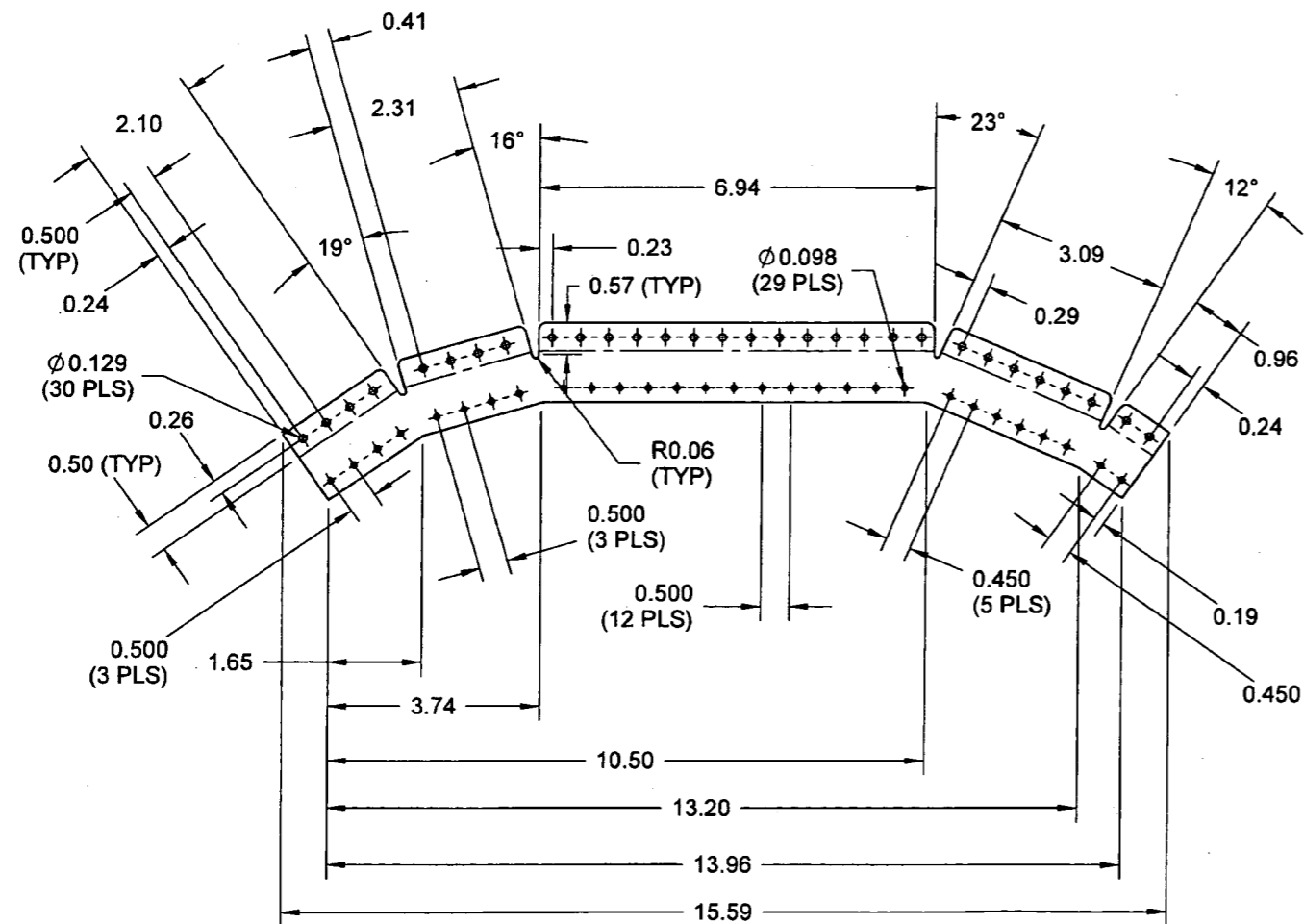
**D3651-5 TOP FLANGE BEND DETAIL** B  
(MAKE FROM D3651-5F FLAT PATTERN)

- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 (26 GAUGE) SHEET, PER MIL-S-5019 (REF. DART SPEC. M304S26GA)
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: NONE
  - 7) WEIGHT: 0.02 lbs

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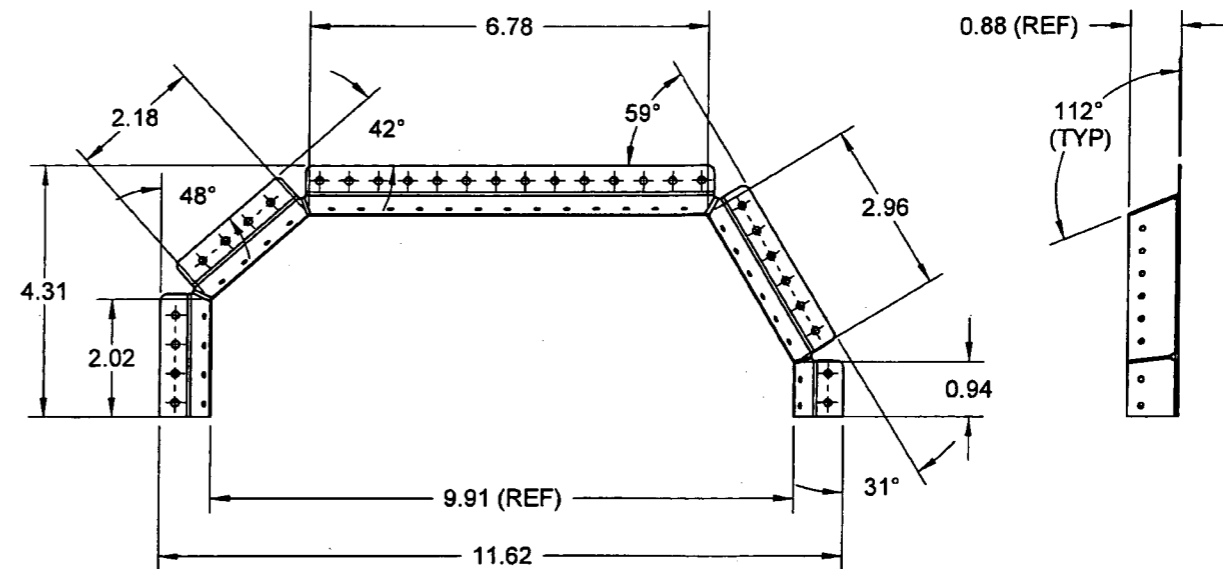
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**D3651-7F FLAT PATTERN** B

**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 (26 GAUGE) SHEET, PER MIL-S-5019 (REF. DART SPEC. M304S26GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.02 lbs

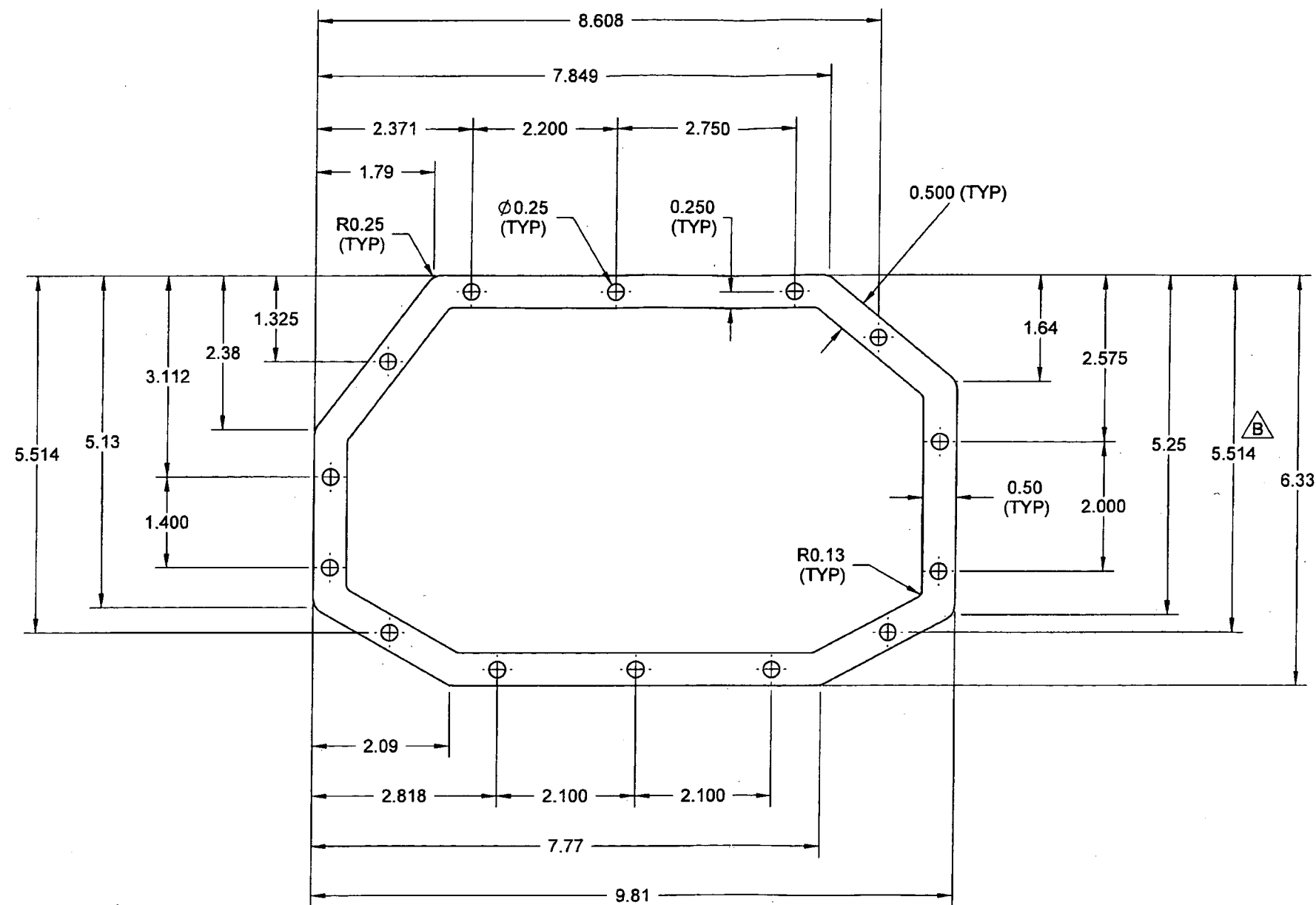


**D3651-7 BOTTOM FLANGE BEND DETAIL** B  
(MAKE FROM D3651-7F FLAT PATTERN)

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MFG. APPR.		D3651	SHEET 6 OF 9
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# **D3651-9 INSIDE DOUBLER**

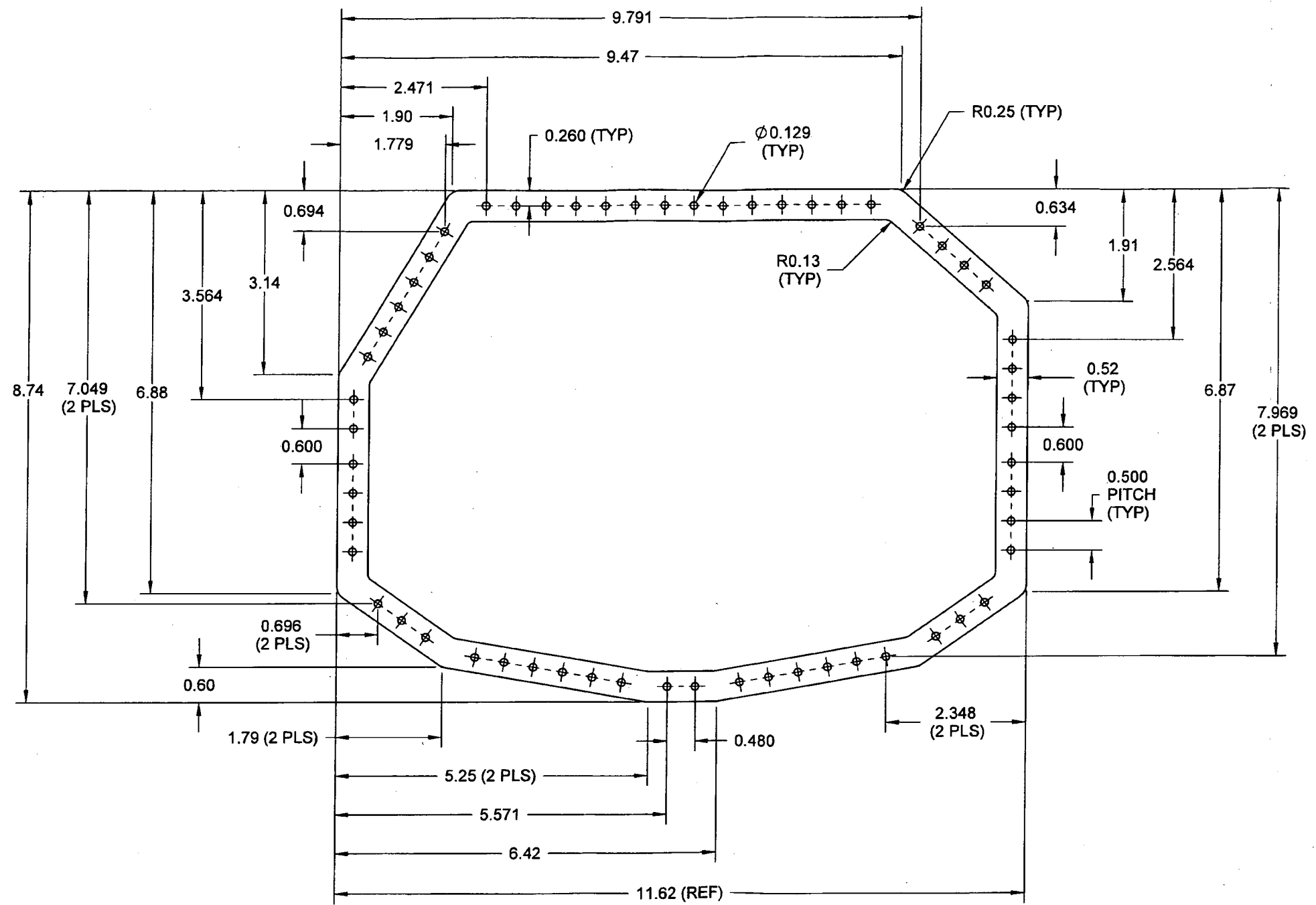
## **NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 (26 GAUGE) SHEET, PER MIL-S-5019 (REF. DART SPEC. M304S26GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.07 lbs

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MFG. APPR.	WLE	D3651	SHEET 7 OF 9
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**D3651-13 OUTSIDE DOUBLER**

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- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 (26 GAUGE) SHEET, PER MIL-S-5019 (REF. DART SPEC. M304S26GA)
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: NONE
  - 7) WEIGHT: 0.10 lbs

DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
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